

# Work Order ID 50893

July 24, 2009 6:35:04 AM



Page 1

Item ID: D6019-128  
Revision ID: A  
Item Name: Crosstube Material

Accept



Setup Start



Stop




Start Date: 7/27/09 Start Qty: 20.00 18  
Required Date: 10/09/09 Req'd Qty: 20.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:  Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D6019	Rev A

100

0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 10125 ☐ a) Order as per Dwg D6019 ☐ b) Material: 2.750 x 0.313 wall 7075-T6/T6511 (WW-T-700/7 or QQ-A-225/9 or QQ-A-200/11) seamless aluminum tube ☐ c) Minimum ultimate tensile strength = 77 ksi ☐ d) Minimum tensile yield strength = 66 ks

u 87.07.24

110

0.00



Receive & Inspect for Damage & Mat'l Certs

Packaging

Memo

0.00

Packaging

Ensure material certification is attached

8/5/25 18

120

0.00



QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

Ensure Material certification comply to Dwg D6005

27 8/10/06

418 f

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 50893



Page 2

July 24, 2009 6:35:04 AM

Item ID: D6019-128

Accept



Setup Start



Revision ID: A

Stop



Item Name: Crosstube Material

Start Date: 7/27/09 Start Qty: 20.00



Cust Item ID:

Required Date: 10/09/09 Req'd Qty: 20.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Chemical Conversion Coat per QST005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing	<i>Mos/10/09</i>	<i>N/A</i>							
140 	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									
150 	Identify as per dwg & Stock Location <i>26</i>	0.00							
Packaging	Memo	0.00							
Packaging									

*0.00 09 - 10 - 04 (6)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 50893

July 24, 2009 6:35:04 AM



Page 3

Item ID: D6019-128

Accept



Setup Start



Revision ID: A

Stop



Item Name: Crosstube Material

Start Date: 7/27/09 Start Qty: 20.00



Cust Item ID:

Required Date: 10/09/09 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/09

wf 09-10-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_




NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

July 24, 2009 6:37:43 AM

[illegible]**Required Date:** 10/09/09

**Required Qty: 20.00**

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6019-128PRevA		Purchased	No				Each	0.0000	1.0000			
												
Crosstube Material												

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

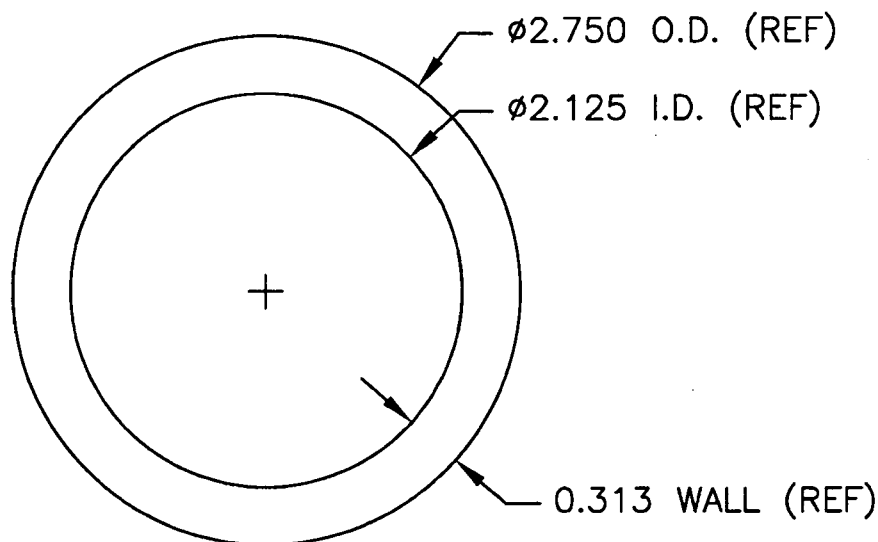
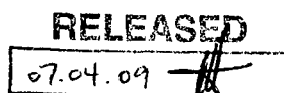




DESIGN qp	DRAWN BY qp	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D6019	REV. A SHEET 1 OF 1
DATE 06.11.03		TITLE CROSSTUBE MATERIAL	SCALE 1:1
A	06.11.03	NEW ISSUE	

WU 50893

## SPECIFICATION CONTROL DRAWING



### NOTES

- 1) D6019-XXX CROSSTUBE  
LENGTH

WHERE XXX IS LENGTH IN INCHES  
EG. 128" LONG TUBE: D6019-128

- 2) MATERIAL: 2.750 OD x 0.313 WALL 7075-T6/T6511 (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11) SEAMLESS ALUMINUM TUBE.  
MINIMUM ULTIMATE TENSILE STRENGTH = 77 ksi  
MINIMUM YIELD TENSILE STRENGTH = 66 ksi
- 3) TOLERANCES ARE PER ASTM B210 AS FOLLOWS:  
O.D.:  $\pm 0.006$  MEAN ( $\pm 0.012$  INCLUDING OVALITY)  
WALL:  $\pm 0.015$  MEAN ( $\pm 0.038$  INCLUDING ECCENTRICITY)  
LENGTH: XXX  $+0.125/-0.000$   
STRAIGHTNESS: 0.010" DEVIATION / 12" LENGTH
- 4) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 5) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO10125

Purchase Order Date 7/24/09

PO Print Date 7/24/09

Page Number 1 of 1

Order From :

VE-ALU001

ALUMINIUMWERK UNNA AG  
UELZENER WEG 36, 59425 UNNA,  
GERMANY,  
DE

Contact Name		Buyer	Linda Lacelle
Vendor Phone	303 755 5672	Requisition Nbr	
Vendor Fax	303 755 5936	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	USD
		FOB	

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D6008-132P A	Crosstube extrusion	10/09/09 Yes	20.00 Each	Yours ppd	\$897.0000	\$17,940.00

Special Inst: PER DRWG D6008 REV.A  
MATERIAL: 3.250 .0438 WALL X 132"L  
7075-t6/t6511 (WW-T-700/7 OR QQ-A-  
225/9 OR QQ-A-200/11)  
SEAMLESS ALUM. TUBE  
MIN ULTIMATE TENSILE  
STRENGTH=77KSI  
MIN. TENSILE YIELD STRENGTH=66KSI

2	D6019-128P A	Crosstube Material	7/24/09 Yes	20.00 Each	Yours ppd	\$567.0000	\$11,340.00
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Special Inst: PER DRWG D6019 REV A  
MATERIAL: 2.750 X 0.313 WALL  
7075-T6/T6511 (WW-T-700/7 OR QQ-A-  
225/9 OR QQ-A-200/11)  
SEAMLESS ALUM TUBE  
MIN ULTIMATE TENSILE  
STRENGTH=77KSI  
MIN TENSILE YIELD STRENGTH=66KSI

MATERIAL CERTIFICATION  
REQ'D UPON DELIVERY

PO Total: \$29,280.00

Change Nbr: 1

Change Date: 7/24/09

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable

# delivery note

## 49401

page: 2  
date: 3.09.2009  
customer: 40980

number of packages: 1  
number of pieces: 12

item	quantity	unit	net kgs
002	18,000	PC	

AWU article: 21755 / Tariff no. 76082081

Customer article: D6019-128 2.750 X 0.313 X 128

product: TUBES / seamless extruded / EN AW-7075 / round

condition: T 6511 / AMS-QQ-A-200/11

outer diameter:	2,750 INCH Tol.	+0,012	-0,012
tol.for mean OD		+0,006	-0,006
inner diameter:	2,124 INCH		
wall thickness:	0,313 INCH Tol.	+0,031	-0,031
fixed length	128,000 INCH Tol.	+0,125	

inspection cert.acc. to EN10204/3.1 / RM 531 / Rp0,2: 455

straightness 0,01 INCH / 1 FEET / RMS outer 25

2.750" OD 0.313"Wall, 128" lengths

Part Number D6019-128 crosstube

Surface Finish max. RMS 25

Tolerances per ASTM B210 / your drawing D6019

Tubes protected with corrosion protective oil

Tubes line marked

Packing: seaworthy wooden cases

number of packages: 1

number of pieces: 18

Terms of payment: 30 days after date of delivery

terms of delivery: DDP(Delivered,Duty,Paid)

weight:	gross	739,000	net	537,000
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Packstücke

customer address:

DART AEROSPACE LTD.

1270 Aberdeen Street

CDN K6A 1K7 HAWKESBURY

ON

Kanada

# Abnahmeprüfzeugnis 3.1 - EN 10204:2004

Inspection Certificate 3.1 - EN 10204:2004 / Certificat de Reception 3.1- EN 10204:2004

**Kunde:** Dart Aerospace Ltd.  
**Client:**

1270 Aberdeen Street  
K6A1K7 Hawkesbury, ON Canada

**Zeugnisnummer:** 794/09

**Cert No. / No. du certificat:**

**Bestellnummer:** PO10125

**Order No. / No. de commande**

**Auftrag:** 33209/2

**Our Reference/Notre Ref.:**

**Produkt:** Rohre nahtlos gepresst

**Product / Produit:** Tubes seamless extruded Tubes file sur aiguille

**Spezifikation:** AMS - QQ - A - 200/11E; Spezifikation Dart Aerospace  
**Specification:** D6007

**Werkstoff:** EN AW-7075

**Alloy/Alliage:** 3.4365

**Zustand:** T 6511

**Temper/État:**

**Abmessung** 2,750 INCH x 2,124 INCH x 0,313 INCH x 128,000 INCH  
**Size / Dimension** D6019-128 2.750 X 0.313 X 128

**Kennzeichnung** Alunna-Cert No.794/09-7075-T6511-Cast No.2680-AMS-QQ A200/11-2.750" Od x 0.313" Wall-Heat No.400149-  
**Marking/Marquage:** Lot33209/2-P.O.10125

**Lieferung:** Stück/pcs. kg/kgs  
**Delivered Material / Matériel délivré:** 18 255,00

## 1. Chemische Analyse

## Chemical Analysis / analyse chimique

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Pb	Zr	Bi	Sn	Ni
Charge/ min.			1,2		2,1	0,18	5,1						
Cast No. max.	0,40	0,50	2,0	0,30	2,9	0,28	6,1	0,20					
2680/09	0,091	0,212	1,391	0,042	2,484	0,199	5,725	0,034	0,002	0,0237	0,0001	0,0012	0,0040

Elemente ohne Angabe < 0,01 % / Elements without indication < 0,01 %

Products are in accordance with applicable RoHS

## 2. Mechanische Eigenschaften

## Mechanical Properties / Valeurs Mécaniques

Anforderungen Specification	Rm N/mm <sup>2</sup>	Rp0,2 N/mm <sup>2</sup>	A5 %	A 50 %	HB	Heat Lot No.
min:	531	455				
max:						
1	601	557		10,0	167	400149 - 18 pcs.

RMS: außen 25 - max. 14,0 µ"

### Ergebnis der Prüfungen:

Es wird bestätigt, daß die Lieferung geprüft wurde und den Vereinbarungen bei der Bestellannahme entspricht

### Test results:

We confirm that the delivery has been tested and applies to the agreements made on receipt of the order

### Resultats:

Nous confirmons que la livraison a été contrôlée et correspond avec les conventions faites à la réception de la commande

kocurs

03.09.2009



Zertifiziert nach DIN EN ISO 9001:2000 u. DIN EN 9100:2003

gültig bis 2010-11-11

Zertifikat- Register- Nr.: 001959 QM; 001959 ASH

Aluminiumwerk Unna AG, Uelzener Weg 36, 59425 Unna, Germany

*[Signature]*  
Abnahmebeauftragter



**Boxmarking:**

We hereby declare that the wooden packing material are totally free from bark and apparently

**free from live plant pests**

S:\VERSAND\USA\_Pack\Iste\33209\_2

# Abnahmeprüfzeugnis 3.1 - EN 10204:2004

Inspection Certificate 3.1 - EN 10204:2004 / Certificat de Reception 3.1- EN 10204:2004

**Kunde:** Dart Aerospace Ltd.  
**Client:**

1270 Aberdeen Street  
K6A1K7 Hawkesbury, ON Canada

**Zeugnisnummer:** 794/09  
**Cert No. / No. du certificat:**

**Bestellnummer:** PO10125  
**Order No. / No. de commande:**

**Auftrag:** 33209/2

**Our Reference/Notre Ref.:**

**Produkt:** Rohre nahtlos gepresst  
**Product / Produit:** Tubes seamless extruded Tubes file sur aiguille

**Spezifikation:** AMS - QQ - A - 200/11E; Spezifikation Dart Aerospace  
**Specification:** D6007

**Werkstoff:** EN AW-7075  
**Alloy/Alliage:** 3.4365

**Zustand:** T 6511  
**Temper/État:**

**Abmessung:** 2,750 INCH x 2,124 INCH x 0,313 INCH x 128,000 INCH  
**Size / Dimension:** D6019-128 2.750 X 0.313 X 128

**Kennzeichnung:** Alunna-Cert No.794/09-7075-T6511-Cast No.2680-AMS-QQ A200/11-2.750" Od x 0.313" Wall-Heat No.400149-  
**Marking/Marquage:** Lot33209/2-P.O.10125

**Lieferung:** Stück/pcs. kg/kgs  
**Delivered Material / Matériel délivré:** 18 255,00

## 1. Chemische Analyse Chemical Analysis / analyse chimique

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Pb	Zr	Bi	Sn	Ni
Charge/ min.			1,2		2,1	0,18	5,1						
Cast No. max.	0,40	0,50	2,0	0,30	2,9	0,28	6,1	0,20					

2680/09 0,091 0,212 1,391 0,042 2,484 0,199 5,725 0,034 0,002 0,0237 0,0001 0,0012 0,0040

Elemente ohne Angabe < 0,01 % / Elements without indication < 0,01 % Products are in accordance with applicable RoHS

## 2. Mechanische Eigenschaften Mechanical Properties / Valeurs Mécaniques

Anforderungen	Rm	Rp0,2	A5	A 50	HB	Heat Lot No.
Specification	N/mm <sup>2</sup>	N/mm <sup>2</sup>	%	%		
min:	531	455				
max:						
1	601	557		10,0	167	400149 - 18 pcs.

RMS: außen 25 - max. 14,0 µ"

**Ergebnis der Prüfungen:** Es wird bestätigt, daß die Lieferung geprüft wurde und den Vereinbarungen bei der Bestellannahme entspricht

**Test results:** We confirm that the delivery has been tested and applies to the agreements made on receipt of the order

**Resultats:** Nous confirmons que la livraison a été contrôlée et correspond avec les conventions faites à la réception de la commande

**Kocurs:**  
03.09.2009



Zertifiziert nach DIN EN ISO 9001:2000 u. DIN EN 9100:2003

gültig bis 2010-11-11

Zertifikat- Register- Nr.: 001959 QM; 001959 ASH

Aluminiumwerk Unna AG, Uelzener Weg 36, 59425 Unna, Germany

*[Signature]*  
Abnahmebeauftragter

# Abnahmeprüfzeugnis 3.1 - EN 10204:2004

Inspection Certificate 3.1 - EN 10204:2004 / Certificat de Reception 3.1- EN 10204:2004

**Kunde:** Dart Aerospace Ltd.  
Client:

1270 Aberdeen Street  
K6A1K7 Hawkesbury, ON Canada

**Zeugnisnummer:** 794/09 2nd edition  
Cert No. / No. du certificat:

**Bestellnummer:** PO10125  
Order No. / No. de commande

**Produkt:** Rohre nahtlos gepresst  
Product / Produit: Tubes seamless extruded

**Auftrag:** 33209/2  
Our Reference/Notre Reference:

**Spezifikation:** AMS - QQ - A - 200/11E; Spezifikation Dart Aerospace D6007  
Specification:

**Werkstoff:** 7075  
Alloy/Alliage:

**Zustand:** T 6511  
Temper/Etat

**Abmessung:** 2,250 INCH x 2,124 INCH x 0,313 INCH x 128,000 INCH  
Size / Dimension: D6019-128 2 750 X 0.313 X 128

**Kennzeichnung:** Alunna-Cert No.794/09-7075 T6511-Cast No.2680-AMS-QQ A200/11 2,750" Od x 0,313" Wall Heat No.400149-  
Marking/Marquage: Lot33209/2-P.O.10125

**Lieferung:** pcs lbs  
Delivered Material / Matériel délivré: 18 562

## 1. Chemische Analyse Chemical Analysis / analyse chimique

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Pb	Zr	B	Sn	Ni
Charge/ min.			1,2		2,1	0,18	5,1						
Cast No. max.	0,40	0,50	2,0	0,30	2,9	0,28	6,1	0,20					
2680/09	0,091	0,212	1,391	0,042	2,484	0,199	5,725	0,034	0,002	0,0237	0,0001	0,0012	0,0040

Country of Manufacture: Germany

Elements without indication < 0.01 %

## 2. Mechanische Eigenschaften Mechanical Properties / Valeurs Mécaniques

Anforderungen Requirements	tensile (Rm) ksi	yield (Rp0,2) ksi	elongation 2" %	elongation 5" %	Hardness HB	Heat Lot No.
min.	77,0	66,0				
max.						
1	87,145	80,765	10,0		167	400149-18

S  
02/10/06

RMS: außen 25 - max. 14,0 µ"

**Ergebnis der Prüfungen:** Es wird bestätigt, daß die Lieferung geprüft wurde und den Vereinbarungen bei der Bestellannahme entspricht

**Test results:** We confirm that the delivery has been tested and applies to the agreements made on receipt of the order

06.11.2005

Kr



Certified acc. DIN EN ISO 9001:2000 and DIN EN 9100:2003

valid until 2010-11-11

Cert.- Reg. No.: 001959 OM; 001959 ASH

Aluminiumwerk Unna AG, Uetziener Weg 36, 59425 Unna, Germany

ALUnna

Abnahmebeauftragter